

Date:
User:

Monday, 22/10/2007 2:17:12 PM
Linda Lacelle

Dart Aerospace Ltd.

Process Sheet

Split

Customer : CU-DAR001 Dart Helicopters Services
Job Number : 35295 - 1
Estimate Number : 12578
P.O. Number :
This Issue : 22/10/2007 S.O. No. :
Prsht Rev. : NC
First Issue : 1 /
Previous Run : 35029 Type : SMALL / MED FAB

Drawing Name : ARM
Part Number : D3560041
Drawing Number : D3560 UNDER REVIEW
Project Number : N/A
Drawing Revision : C
Material :
Due Date : 29/10/2007

Written By :
Checked & Approved By :
Comment :
Est Rev: A New Issue 07.05.24 EC
est rev B ECN 987 07.10.09 EC verified by: DD

Qty: *10* Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation:

Description:

1.0 M6061T6B0500X05000

6061-T6 Bar .50" x 5.0"



Comment: Qty.: 1.4648 f(s)/Unit Total: 20.5065 f(s)
6061-T6 Bar 0.50" x 5.00"

Batch: *M105950*



2.0 BAND SAW

BAND SAW



Comment: BAND SAW
Cut blanks 16.750" long



3.2 07/10/24 (12)

3.0 HAAS1

HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1



3.2 07/10/24 (12)

1- Mill as per Folio FA693 Rev: *AA* & Dwg D3560 Rev: *C*

2-C'sink 0.196" hole on manual mill as per dwg D3560

3-Deburr per dwg D3560

4.0 QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE



SA/BC 07.10.24 (12)

SA/BC 07.10.24 (12)

User:

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARM

Job Number: 35295

Part Number: D3560041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

2.5 27/10/31

6.0

D35921

PLATE



Comment: Qty.: 1.0000 Each(s)/Unit Total: 14.0000 Each(s)

PLATE

B 35331

B 35331

08.08.14 (10)

1407-11-29

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld assembly as per dwg D3560

STEP:

1- clean material (buff bracket and bottom of arm with blue pad)

2- set up bracket and arm on jig

3- preheat bracket and arm with torch

4- clean before welding with brush

5- set up machine to 135 amps

6- weld across bottom and top ends

7- reheat with torch (

8- on one side weld from bottom to top half way

9- same for other side (half way)

10- from half way point weld the rest of the first side (ease off pedal near end)

11- same for remaining side (ease off pedal near end)

SP

SP

SP

SP

SP

SP

SP

SP

SP

SP

SP 08.08.14 (10)

1407-11-29

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

080815 (10)

9.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

08.08.15
08/08/15

(X1)

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Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

SP 08.08.15 (14)

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

12.0

D2808

Spacer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 14.0000 Each(s)

Spacer

batch: B37113

SB 08/08/18 (1)

13.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Press bushing in D3560 arm per dwg D3562

SB 08/08/18 (1)

14.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08.08.18 (1)

15.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: WA

08.08.18

16.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/08/19

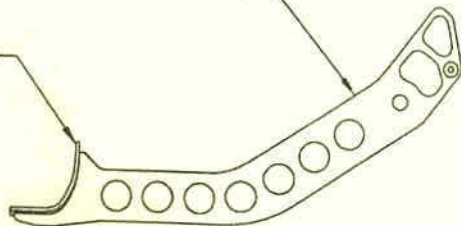
Job Completion



MF 08-08-18

D3560-1 ARM (-041, SHOWN)
OR D3560-2 ARM (-042, OPPOSITE)

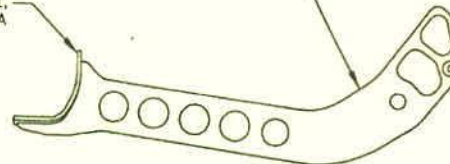
D3592-1 PLATE,
SEE DETAIL A



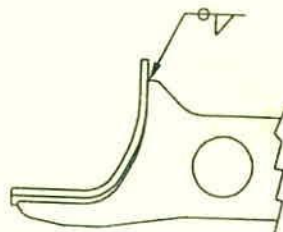
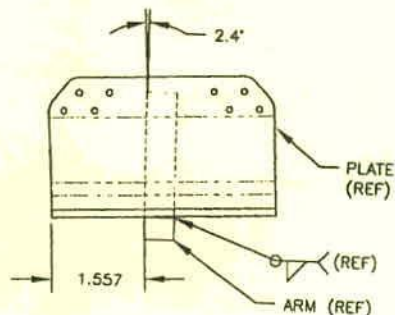
D3560-041 ARM WELDMENT (SHOWN),
D3560-042 ARM WELDMENT (OPPOSITE)

D3560-3 ARM (-043, SHOWN)
OR D3560-4 ARM (-044, OPPOSITE)

D3592-1 PLATE,
SEE DETAIL A



D3560-043 ARM WELDMENT (SHOWN),
D3560-044 ARM WELDMENT (OPPOSITE)



DETAIL A
(SCALE 1:1)

GENERAL NOTES


- 1) WELD PER QSI 004
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

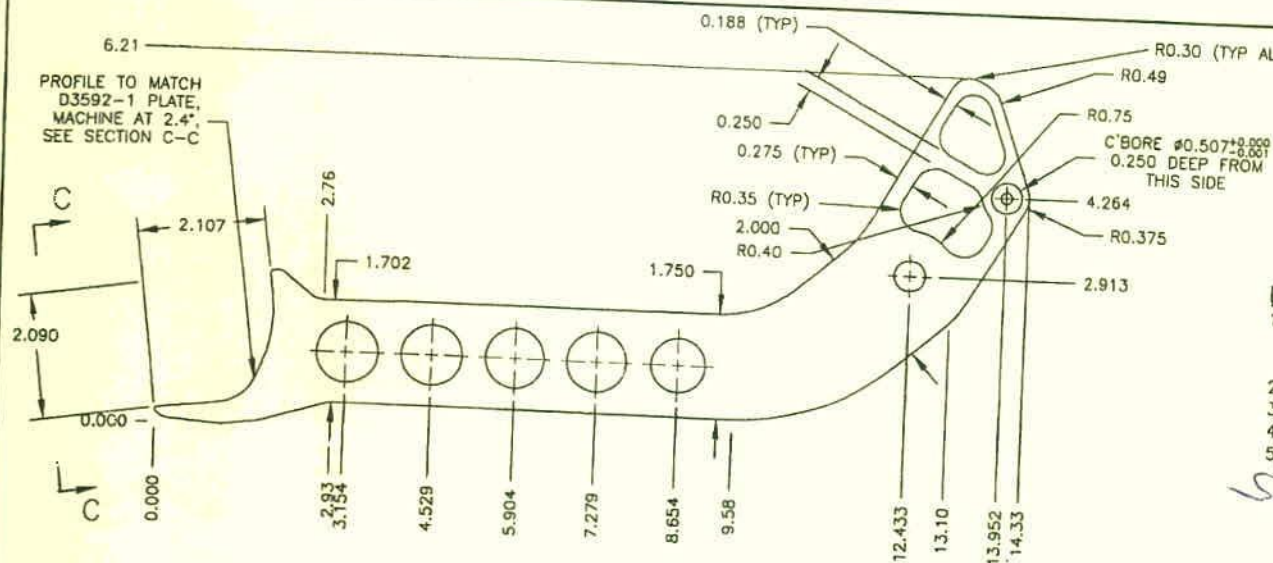
RELEASED
07.06.19
UNDER REVIEW
07.10.22 DE

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C	07.06.19	REMOVE POWDER COAT
B	07.01.15	REDESIGN AS WELDMENT, ADD POCKETS
A	06.09.25	NEW ISSUE
DESIGN	DRAWN BY	DART DART AEROSPACE LTD. WARRICKSLEY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D3560
DATE	07.06.19	TITLE ARM WELDMENT
		REV. C SHEET 1 OF 3 SCALE 1:4

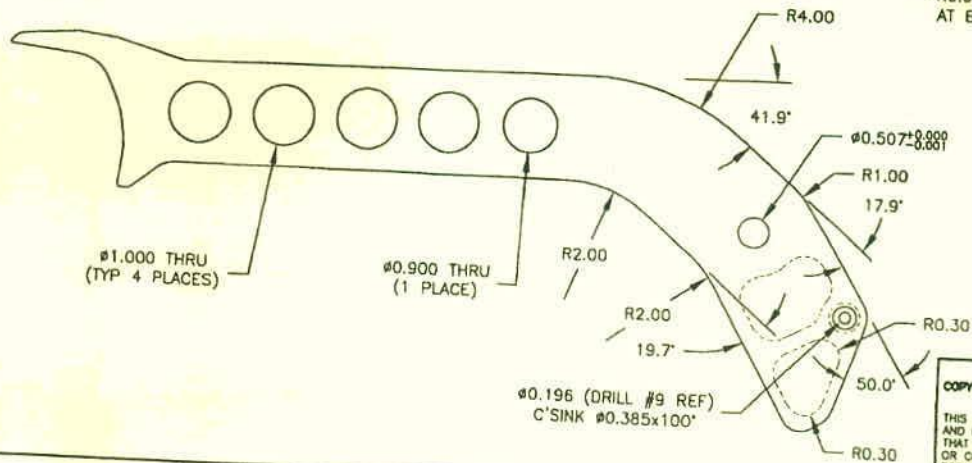
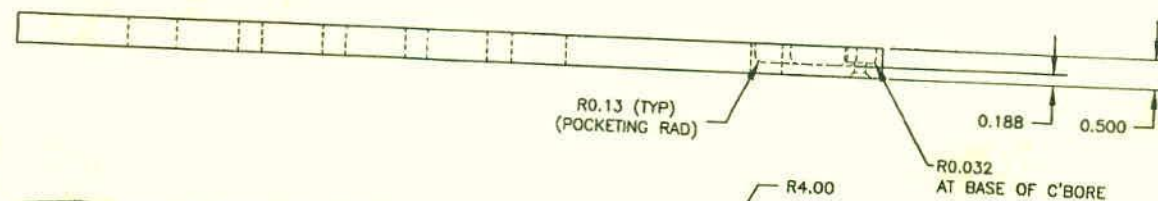
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	CHECKED	JH	APPROVED	JH		
	DATE	07.06.19	TITLE		ARM WELDMENT	



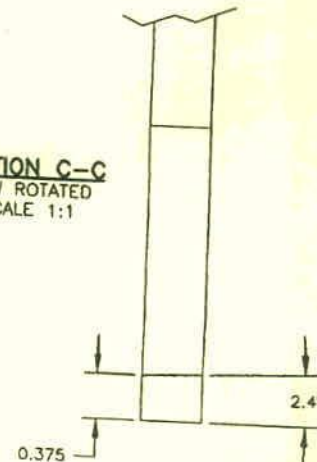
D3560-3 ARM (SHOWN), D3560-4 ARM (OPPOSITE)

- 1) MATERIAL: 6061-T6 ALUMINUM, 0.500 THICK
(QQ-A-200/8 OR QQ-A-250/11, REF DART SPEC.
M6061T6B0.500)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP CORNERS 0.005 TO 0.015

56552 g/m



SECTION C-C
VIEW ROTATED
SCALE 1:1



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07.06.19

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DATE	07.06.19	TITLE	ARM WELDMENT	REV. C	SHEET 3 OF 3
		SCALE	1:2		

